



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D6101-003**  
**Job Sheet 170393**



5038654

Part No: D6101-003

Job Qty: 40 ea ✓

Part Name: Saddle Billet, 7075



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/16/18

Job Tracking No:

Due Date: 2/6/18

Created By: Diane Baker

Type: Stock

Description:

Note: DWG REV B

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation  | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off     |
|-------|------------|--------|------------|----------|-----------|---------|-----------------------|-----------|--------------|
|       |            |        |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |              |
| 100   | Purchasing | 40 pcs | 2/6/18     | 2/6/18   | 0.00      | 0.00    | Purchasing            |           | DAS          |
| 110   | Packaging  | 40 pcs | 2/6/18     | 2/6/18   | 0.00      | 0.00    | Packaging2            |           | 11           |
| 120   | QC         | 40 pcs | 2/6/18     | 2/6/18   | 0.00      | 0.00    | QC6                   |           | 98/02/03     |
| 130   | Packaging  | 40 pcs | 2/6/18     | 2/6/18   | 0.00      | 0.00    | Packaging3-2          |           | SBL 18/02/03 |
| 140   | QC21-SA    | 40 Ea  | 2/6/18     | 2/6/18   | 0.00      | 0.00    | QC21                  |           | ML5          |

Part Op 100 - Issue P/O: 038798 a)Description: Alluminum billet b) 7.875" x 6.250" x 2.00" thick c) Tolerance on all Descriptions: dimensions are +0.030"/-0.000" d) Grain direction along 7.875" length e) Material: 7075-T7351 (QQ-A-250/12) f) Material certification required

110 - Ensure material certification is attached

120 - Ensure Material certification comply to Dwg D6101

130 - LOCATION: MAT046

JAN 16 2017

MLB

### Job Allocations

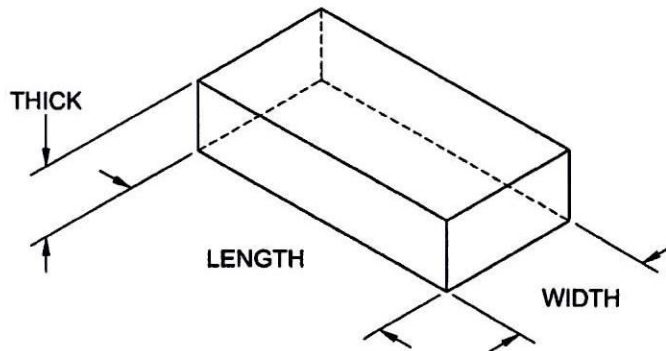
| Operation      | Component Part | Required | Inventory | Allocated | Std Qty |
|----------------|----------------|----------|-----------|-----------|---------|
| 100-Purchasing | D6101-003P     | 40       | 0         | 0         | 0       |

### Part Specifications

Specifications could not be found.

Plex 1/16/18 9:21 AM dart.baker.diane

# SPECIFICATION CONTROL DRAWING



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

**B** ACCEPTABLE SPECIFICATIONS FOR 7075-T7351 ALUMINUM ARE AMS-QQ-A-250/12, QQ-A-250/12, OR ASTM B209

| Part No.  | Alloy                    | Length | Width | Thick | Grain Direction    |
|-----------|--------------------------|--------|-------|-------|--------------------|
| D6101-001 | 7075-T7351 (QQ-A-250/12) | 6.000  | 6.250 | 2.000 | Along 6.000 Length |
| D6101-003 | 7075-T7351 (QQ-A-250/12) | 7.875  | 6.250 | 2.000 | Along 7.875 Length |
| D6101-005 | 7075-T7351 (QQ-A-250/12) | 5.000  | 8.250 | 2.500 | Along 5.000 Length |
| D6101-007 | 7075-T7351 (QQ-A-250/12) | 7.750  | 8.250 | 2.500 | Along 7.750 Length |
| D6101-009 | 7075-T7351 (QQ-A-250/12) | 8.700  | 8.250 | 2.500 | Along 8.700 Length |
| D6101-011 | 7075-T7351 (QQ-A-250/12) | 9.700  | 8.250 | 2.500 | Along 9.700 Length |
| D6101-013 | 7075-T7351 (QQ-A-250/12) | 10.100 | 8.250 | 2.500 | Along 10.10 Length |
| D6101-015 | 7075-T7351 (QQ-A-250/12) | 9.450  | 6.250 | 2.500 | Along 9.450 Length |
| D6101-017 | 7075-T7351 (QQ-A-250/12) | 6.350  | 6.250 | 2.250 | Along 6.350 Length |
|           |                          |        |       |       |                    |
|           |                          |        |       |       |                    |

**RELEASED**  
09/07/15/WJ

|            |                                     |                                                                                                                                                                                                                                                                                          |              |
|------------|-------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| B          | ADDED D6101-015/-017, ADD ASTM B209 | RF                                                                                                                                                                                                                                                                                       | 09.04.23     |
| A          | NEW ISSUE                           | CP                                                                                                                                                                                                                                                                                       | 01.03.30     |
| REV.       | DESCRIPTION                         | BY                                                                                                                                                                                                                                                                                       | DATE         |
| DESIGN     | CP                                  | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                 |              |
| DRAWN      | RF                                  |                                                                                                                                                                                                                                                                                          |              |
| CHECKED    |                                     | DRAWING NO.                                                                                                                                                                                                                                                                              | REV. B       |
| MFG. APPR. |                                     | D6101                                                                                                                                                                                                                                                                                    | SHEET 1 OF 1 |
| APPROVED   |                                     | TITLE                                                                                                                                                                                                                                                                                    | SCALE        |
| DE APPR.   |                                     | SADDLE BILLET, 7075                                                                                                                                                                                                                                                                      | NTS          |
| DATE       | 09.04.23                            | <small>COPYRIGHT © 2001 BY DART AEROSPACE LTD<br/>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> |              |



**Castle Metals®**

A. M. Castle &amp; Co.

PACKING SLIP/  
CERTIFICATE OF CONFORMANCE

Page 1 of 2

Shipment No:3501047

|                                                                                                    |                         |                                                                                        |  |                                                                                         |  |                                                                                              |  |
|----------------------------------------------------------------------------------------------------|-------------------------|----------------------------------------------------------------------------------------|--|-----------------------------------------------------------------------------------------|--|----------------------------------------------------------------------------------------------|--|
| <b>Ship From:</b><br>A. M. CASTLE & CO.<br>2150 ARGENTIA ROAD<br>MISSISSAUGA, ON L5N<br>2K7<br>CAN |                         | <b>Sold To:</b><br>DART AEROSPACE LTD<br>1270 ABERDEEN<br>HAWKESBURY, ON K6A 1K7<br>CA |  | <b>Ship To:</b><br>DART AEROSPACE LTD<br>1270 ABERDEEN<br>HAWKESBURY, ON<br>K6A 1K7 CAN |  | <b>Deliver To:</b><br>DART AEROSPACE LTD<br>1270 ABERDEEN<br>HAWKESBURY, ON<br>K6A 1K7<br>CA |  |
| <b>Date Shipped</b><br>01-FEB-18                                                                   | <b>F.O.B.</b><br>ORIGIN | <b>Freight Terms</b><br>Prepaid                                                        |  | <b>Carrier</b><br>MANITOULIN                                                            |  | <b>BOL No</b><br>3501047-2                                                                   |  |

|                         |                                       |
|-------------------------|---------------------------------------|
| <b>Shipment Details</b> | <b>Final Destination Branch - TOR</b> |
|-------------------------|---------------------------------------|

|                                   |                     |                                                      |                                                                                                                                                                                                                                                                                    |                                 |  |                                 |  |
|-----------------------------------|---------------------|------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------|--|---------------------------------|--|
| <b>Order No</b><br>5014841        | <b>Line No</b><br>2 | <b>Item No</b><br>752237.MO                          | <b>Description</b><br>2.0000 PL.7075.T7351 ALUMINUM. US1.48.5000.144.5000<br>CUT RECTANGLE TO 6.25 IN ( + .0310/- .0000 IN (GRAIN TO RUN<br>ALONG 7.875")) X 7.875 IN ( + .0310/- .0000 IN (GRAIN TO RUN<br>ALONG 7.875")) - ALUMINUM PLATE SAW SPECIFICATIONS:<br>AMS-QQ-A-250/12 |                                 |  |                                 |  |
| <b>Purchase Order No</b><br>38795 |                     | <b>Part Number</b><br>YOUR ITEM NUMBER:<br>D6101-003 |                                                                                                                                                                                                                                                                                    | <b>Ordered Qty</b><br>40.00 PCS |  | <b>Invoice Qty</b><br>40.00 PCS |  |

|                |                                                                                                                                                                                                                                                          |
|----------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Details</b> | ALL PAPERWORK MUST FOLLOW ORDER / CUSTOMER MUST RECEIVE AT TIME OF DELIVERY<br>ALL MATERIAL MUST HAVE IDENTIFYING MARKINGS EX:HEAT #'S<br>Email P/s and certs to: clavoie@dartaero.com<br>END USER: DART AEROSPACE<br>END USE: COMMERCIAL AIRCRAFT PARTS |
|----------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|

|                                  |                                                         |                                                                                                           |                |                  |                   |                    |                                     |
|----------------------------------|---------------------------------------------------------|-----------------------------------------------------------------------------------------------------------|----------------|------------------|-------------------|--------------------|-------------------------------------|
| <b>Delivery No.</b><br>121567575 | <b>Mill/Source</b><br>CONSTELLIUM<br>ROLLED<br>PRODUCTS | <b>Heat Number</b><br> | <b>Mech Id</b> | <b>PCS</b><br>40 | <b>Width (IN)</b> | <b>Length (IN)</b> | <b>Shipped Qty(LBS)</b><br>406.4338 |
|----------------------------------|---------------------------------------------------------|-----------------------------------------------------------------------------------------------------------|----------------|------------------|-------------------|--------------------|-------------------------------------|

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A. M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned.

Date Printed: 01-FEB-2018 03:28:11 PM



**Castle Metals®**

A. M. Castle & Co.

PACKING SLIP/  
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Page 2 of 2

|                                                      |                                                                                   |                   |
|------------------------------------------------------|-----------------------------------------------------------------------------------|-------------------|
| for credit                                           |                                                                                   |                   |
| Reviewed by Authorized Castle Metals Representative: |  | Date: FEB 01 2018 |
|                                                      |                                                                                   | Name:             |





**Constellium**



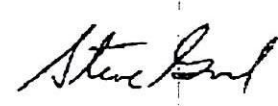
**CERTIFIED TEST REPORT**  
Constellium Rolled Products  
Ravenswood, LLC

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A M CASTLE & COMPANY  
4175 ROYAL DRIVE  
KENNESAW GA  
30144  
US

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A M CASTLE  
1420 KENSINGTON ROAD, SUITE 220  
OAK BROOK IL  
60523  
US

|                                                                                                                                                                                    |      |                 |                                 |                                  |                                    |                                 |  |                            |  |         |  |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------|-----------------|---------------------------------|----------------------------------|------------------------------------|---------------------------------|--|----------------------------|--|---------|--|
| A M CASTLE                                                                                                                                                                         |      | 110561144       |                                 | 4776                             |                                    | INCLUSION                       |  | Serial:20170815-0110561144 |  | Pg 1of4 |  |
| CUSTOMER PURCHASE ORDER NO. & ITEM<br>428378                                                                                                                                       |      |                 |                                 |                                  |                                    | Constellium ORDER NO.<br>211224 |  |                            |  |         |  |
| ALLOY<br>7075                                                                                                                                                                      | CLAD | TEMPER<br>T7351 | GAUGE<br>2.00000 in<br>50.80 mm | WIDTH<br>48.50000 in<br>1,232 mm | LENGTH<br>144.50000 in<br>3,670 mm |                                 |  |                            |  |         |  |
| ITEM ORDERED<br>SPEC PLATE, SAWED<br>MILL FINISH                                                                                                                                   |      |                 |                                 |                                  |                                    |                                 |  |                            |  |         |  |
| CUSTOMER SPECIFICATION<br>AMS 4078J                                                                                                                                                |      |                 |                                 |                                  |                                    |                                 |  |                            |  |         |  |
| PART NUMBER<br>752237                                                                                                                                                              |      |                 |                                 | B/L NUMBER<br>85350              |                                    | DATE SHIPPED<br>08/15/2017      |  |                            |  |         |  |
| WT. SHIPPED<br>11410.000 LB                                                                                                                                                        |      |                 |                                 | NO. OF PIECES<br>000008          |                                    | GOVT. CONTRACT NO.              |  |                            |  |         |  |
| <div style="text-align: right;"> <br/>           Steve Good - Laboratory Manager         </div> |      |                 |                                 |                                  |                                    |                                 |  |                            |  |         |  |

**CERTIFICATION**  
"Constellium Rolled Products, hereby certifies that metal shipped under this order has been inspected and found in conformance with the requirements of the applicable specifications as indicated herein. Any warranty is limited to that shown on Constellium Rolled Products' standard General Terms and Conditions of Sales. Test reports are on file, subject to examination."  
Constellium Rolled Products Ravenswood, LLC  
859 Century Road  
P.O. BOX 68  
RAVENSWOOD, WV 26164 USA

**ALL LOTS ON THIS CERTIFICATION ALSO CONFORM TO THE FOLLOWING REQUIREMENTS:**

ASTM B504 REV 13 2013 100% SONIC W/ 0.125" DEADZONE Class A  
AMS QQ-A-350/12A  
AMS-STD-2154A 2012 TYPE1 CLASS A 100% SONIC MINUS DEADZONE  
ASTM B209-14  
BSS-7055B 2013 CLASS A 100% SONIC TESTED MINUS DEADZONE  
CMMPO25 REV U  
CST1006 REV E 2011 CLASS A 100% SONIC MINUS DEADZONE  
DPS 4.713 REV AK 2012 CLASS A 100% SONIC MINUS DEADZONE  
GAMPS 9101 REV B 2006 CLASS A 100% SONIC MINUS DEADZONE  
MMS 159T  
PS 2121P 2010 CLASS A 100% SONIC MINUS DEADZONE



**Load Details**

| Package    | Net Lbs   | Kg      | Lot     | Piece | Serial | Parent Lot |
|------------|-----------|---------|---------|-------|--------|------------|
| 1001577263 | 1,435.000 | 650.905 | 9394181 | 01    |        |            |
| 1001577263 | 1,435.000 | 650.905 | 9394181 | 02    |        |            |
| 1001577264 | 1,438.000 | 652.265 | 9394181 | 03    |        |            |
| 1001577264 | 1,437.000 | 651.812 | 9394181 | 04    |        |            |
| 1001577356 | 1,423.000 | 645.461 | 9394160 | 01    |        |            |
| 1001577356 | 1,422.000 | 645.008 | 9394160 | 02    |        |            |
| 1001577357 | 1,410.000 | 639.565 | 9394160 | 03    |        |            |
| 1001577357 | 1,410.000 | 639.565 | 9394160 | 04    |        |            |

**Lot: 9394181**



# MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D6101-003  
 DATE: FEB 03 2018

PO BATCH NO.: C38795/5038654

MATERIAL CERT REC'D: yes  
 QUANTITY RECEIVED: 40 pcs  
 QUANTITY INSPECTED: 40 pcs  
 QUANTITY REJECTED: 0

THICKNESS ORDERED: 2.000  
 THICKNESS RECEIVED: 2.000  
 SHEET SIZE ORDERED: N/A  
 SHEET SIZE RECEIVED: N/A

| DESCRIPTION                                        | NCR<br>(Check<br>Y/N)                   | COMMENTS               |
|----------------------------------------------------|-----------------------------------------|------------------------|
| SURFACE DAMAGE                                     | Y <input checked="" type="checkbox"/> N |                        |
| CORRECT FINISH                                     | <input checked="" type="checkbox"/> Y N |                        |
| CORROSION                                          | Y <input checked="" type="checkbox"/> N |                        |
| CORRECT GRAIN DIRECTION                            | <input checked="" type="checkbox"/> Y N |                        |
| CORRECT MATERIAL PER M-DRAWING                     | <input checked="" type="checkbox"/> Y N | <u>Ams-QQ-A 250/12</u> |
| CORRECT THICKNESS                                  | <input checked="" type="checkbox"/> Y N |                        |
| PHOTO REQUIRED                                     | Y <input checked="" type="checkbox"/> N |                        |
| CORRECT REF # TO LINK CERT                         | <input checked="" type="checkbox"/> Y N | <u>Heat # 9394181</u>  |
| CORRECT MATERIAL IDENTIFICATION                    | <input checked="" type="checkbox"/> Y N |                        |
| CORRECT M# ON THE MATERIAL                         | <input checked="" type="checkbox"/> Y N |                        |
| DOES THIS MATERIAL REQUIRE<br>ENGINEERING SIGN OFF | Y <input checked="" type="checkbox"/> N |                        |
| DOES THIS REQUIRE AN<br>EXTRUSION REPORT           | Y <input checked="" type="checkbox"/> N |                        |

| CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK<br>RECORD RESULTS BELOW |     |     |       |       |         |
|-----------------------------------------------------------------------------------|-----|-----|-------|-------|---------|
|                                                                                   | HRC | HRB | DUR A | DUR D | WEBSTER |
| TYPE OF MATERIAL                                                                  |     |     |       |       |         |
| SIZE OF TEST SAMPLE                                                               |     |     |       |       |         |
| HARDNESS / DUROMETER READING                                                      |     |     |       |       |         |

*testers located in the Quality Office*

| QC 18 INSPECTION                                                       | ENGINEERING SIGNOFF (if required)   |
|------------------------------------------------------------------------|-------------------------------------|
| INSPECTED BY: <u>DAS</u><br><u>11</u><br>DATE: <u>9-89 FEB 03 2018</u> | SIGNED OFF BY: _____<br>DATE: _____ |

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in.